



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3403-3
Job Sheet 178421



Part No: D3403-3

Job Qty: 30 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: ~~6/8/18~~ June 30

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3403 REV F IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		6/8/18	0.00	0.00	Start Up Machining-2		JRD 18/7/5
100	Hardinge	30 pcs		6/8/18	0.02	3.65	Hardinge		JRD 18/7/5
120	QC	30 pcs		6/8/18	0.00	0.00	QC8		DAS 18/10/17
130	Packaging	30 pcs		6/8/18	0.00	0.00	Packaging3-1	6	JUL 16 2018
140	QC21-SA	30 Ea		6/8/18	0.00	0.00	QC21	9-89	DAS 53 9-89

Part Op Descriptions: 100 - 1- Turn as per Folio FA558 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____ JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	5.7600 ft (.192 ea)	90-Start up Operation	5082805

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	6	71	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	2.165inches + 0.010 - 0.000	2.175 2.165		2.172
2	Bushing	0.060inches ± 0.005	0.065 0.055		.061
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		.261
4	Bushing	0.750inches ± 0.010	0.760 0.740		.746
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		.424
6	Bushing	0.313inches ± 0.010	0.323 0.303		.313
7	Bushing	60.0Degrees ± 0.5	60.5 59.5		60°
8	Bushing	0.010inches ± 0.010	0.020		.01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Sten #: _____

Des: _____

Part: D3403-3
 Job No: 178421
 Serial No/Batch: S089240
 Revision: F
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 07/06/18



MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause			
Environment	☐	Nc	☐
Design	☐	Op	☐
Doc/Data	☐	Of	☐
Equip/Tooling	☐	Su	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
		Crimp/Kink/Ripple/Wave	☐
		Cuffs	☐
		Crushing	☐
		Heat Treat	☐
		Wave/Twist in Tube	☐
		Marks/Chatter	☐
		Inspection Incomplete/Unqualified	☐
		Contamination	☐
		Countersink	☐
		Cut Too Short	☐
		Instructions Incomplete/Unclear	☐
		Drill Holes	☐
		er Loss/Surge	☐
		o/Program	☐
		n	☐
		d	☐
		Wrong Stock Pulled	☐
		Out of Sequence	☐
		Off-set	☐
		Mislabeled	☐
		Fit/Function	☐
		Misaligned/off center	☐
		Positioned Wrong	☐
		Outside Dimensions	☐
		Over/Under tolerance	☐
		Part Incorrect	☐
		Part Lost/Missing	☐
		Part Moved	☐
		Drawing	☐
		Finish	☐
		Misread	☐
		Turning Sequence	☐
OTHER : _____			